Eate:

Wednesday, 26/11/2008 12:46:04 PM

User:

Julie Dawson

## **Process Sheet**

Customer

Prsht Rev.

First Issue

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number** 

S.O. No. :

: 43751 : 10993

P.O. Number

Previous Run

This Issue

: 26/11/2008

: NC

: //

: 41666

Written By **Checked & Approved By** 

Comment

: Est E est

Type

07.07.06 rev E dwg

: MACHINED PARTS

Now turned on Cobra NG EC

**Drawing Name** 

: CROSSBOLT SPACER

**Part Number** 

: D2579

**Drawing Number** Project Number : D2579 REV E : N/A : E

**Drawing Revision** 

Material

: 20/12/2008 **Due Date** 

Qty:

500 Um:

Each

Stock

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description: 6061-T6 RD Tube .500 x.058W

1.0 M6061T6T0500W058

Comment: Qty.:

0.3762 f(s)/Unit Total: 188.1075 f(s)

6061-T6 Tube .500 x.058W

Material: 6061-T6 (WW-T-700/6) or 5052-H32 (WW-T-700/4)

0.500 Dia x 0.058 Wall

Batch 109115

HARDINGE CNC LATHE SMALL

2.0

3.0

HARDINGE

Comment: HARDINGE CNC LATHE SMALL

Machine as per Folio FA245

QC2



Comment: INSPECT

PARTS AS THEY COME OFF MACHINE QC8 4.0

SECOND CHECK



Comment: SECOND CHECK 5.0 PACKAGING 1

PACKAGING RESOURCE #1



Identify and Stock Location I







Comment: PACKAGING RESOURCE #1





# **Dart Aerospace Ltd**

W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE				Dat	e Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
v -									
Part No	:	PAR #:	Fault Categ	jory:	NCR: Ye	s No	DQA:	Date: _	
Resolution:		esolution:	Disposition:		_ QA: N/C Closed: Date:				
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NO	CR)			
		Description of NC	Corrective Action Section		on B	V	Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	n &	Section C	Chief Eng	QC Inspector

NOTE: Date & initial all entries

Date: User:

Wednesday, 26/11/2008 12:46:04 PM

Julie Dawson

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 43751

Part Number: D2579

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



MF 08-12-61

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



# **Dart Aerospace Ltd**

W/O:			WC	RK ORDER CHAN	GES				
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		3			1				
		·							
		•							
14.									·
Part No	:	PAR #:	Fault Cate	gory:	NCR: Ye	es No <b>D</b>	QA:	Date: _	
	R	esolution:	Disposition	າ:	QA: N/C	Closed: _		Date: _	
NCR:		\	WORK ORDI	ER NON-CONFORM	ANCE (N	CR)			
DATE	OTED	Description of NC	<u> </u>		ection B	Ver	ification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng			ection C	Chief Eng	QC Inspector
İ									
			•						
			*						
						1			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order: 4375 \

Description: Cross Bolt Spacer

Part Number: D2579

Inspection Dwg: D2579 Rev: E

Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.070	+/-0.030	4.070				
0.058	+/-0.010	4.070	/			
<u>.</u>						
		- T- 18				
					- <del></del>	
Mary.						
· · · · · · · · · · · · · · · · · · ·						
<u> </u>						
·						
111			17.7			
		,				

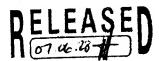
Measured by:	Audited by:	Prototype Approval:	N/A
Date: 08/11/28	Date: 65/11/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.11.27	New Issue	KJ/RF	
В	07.09.06	Dwg Rev updated	KJ/JLM	E
			/ ()	

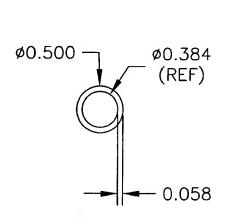
	्राप्त स्थापना । जिल्लाका विकास स्थापना । जिल्लाका विकास स्थापना । जिल्लाका विकास स्थापना । जिल्लाका विकास स्थ स्थापना स्थापना । जिल्लाका स्थापना	and the state of t				
4 5.						
1						
1						
:	ja e					
		1 ·				
2						
e E						
f. f.						
					(4)	
			+			•
200						•
Mê Le .		and of the artificial in				

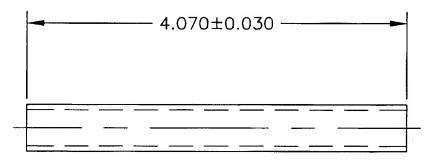


DESIG	N ##	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANAD	
CHEC	KED 11	APPROVED	DRAWING NO.	REV. E
	一概	#	D2579	SHEET 1 OF 1
DATE			TITLE	SCALE
07.0	04.17		CROSS BOLT SPACER	1:1
Α		96.09.16	NEW ISSUE	
В		06 12 05	0.065 WALL WAS 0.035 WALL	



07.0	04.17	CROSS BOLT SPACER 1:1
Α	96.09.16	NEW ISSUE
В	96.12.05	0.065 WALL WAS 0.035 WALL
С	97.02.21	0.058 WALL WAS 0.065 WALL
D	99.05.19	4.070 LENGTH WAS 4.100 (TSR A1095)
E	07.04.17	UPDATE NOTES





#### D2579 CROSS BOLT SPACER

#### D2579 CROSS BOLT SPACER

1) MATERIAL:

6061-T6 TUBING PER WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8

(REF DART SPEC M6061T6T0500W058)

**SHOP COPY** 

2) FINISH:

NONE

RETURN TO

3) ALL DIMENSIONS ARE IN INCHES

ENGINEERING

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY SUBJECT TO AMENDMENT

NO 43757

Copyright @ 1996 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.